

Date: Monday, 7/16/2007 2:43:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH 350/355
Job Number	: 33548		
Estimate Number	: 10208		
P.O. Number	: <i>N/A</i>	Part Number	: D350607043
This Issue	: 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D350-607 REV F P7-9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 33389	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/30/2007
Checked & Approved By	: <i>[Signature]</i> 07.07.17	Qty:	1 Um: Each
Comment	: Est Rev:E as Per DSI9318 06-01-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD350-607-043 CHG003

*KIS 07.07.24* ①

2.0	33548A	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY

D2989-041 B *33548A**ml 07/08/02*

3.0	33548B	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY

D2989-043 B *33548B**ml 07/08/02*

4.0	33548C	BASKET BASE ASSEMBLY (350)
-----	--------	----------------------------



Comment: Sub-Component BASKET BASE ASSEMBLY (350)

D2221 B *33548C**ml 07/08/02*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

6.0	NAS1515H4	Washer
-----	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000-Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 NAS1515H4 WASHER *M 10/428**[Signature]**07/08/01 ①*

Date: Monday, 7/16/2007 2:43:31 PM  
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## Process Sheet

Customer: CU-DAR001-Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 33548

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

7.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

5 D2022-101 Spacer B30543

8.0	D2258200	Weight Placard 200lb
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label B32276

9.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B32572

10.0	D2530	Handle Weldment
------	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B31787

11.0	D2535	Spring
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B31986

12.0	D2537	Bushing
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B33815

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Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 33548

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	D27283	Dart Logo label large
------	--------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label B22553

14.0	D2931	Bumper
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper B21139

15.0	AN316A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M104093

16.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-13A Bolt M104746

17.0	AN422A	Bolt
------	--------	------



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

7 AN4-22A Bolt M102959

18.0	AN517A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M104016

*Handwritten signature and date: 07/08/07*

Date: Monday, 7/16/2007 2:43:31 PM  
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## Process Sheet

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Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 33548

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

19.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer M104156

20.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

14 AN960JD416 Washer M104215

21.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M104336

22.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M104156

23.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M104433 M103344

24.0	MS20600AD4W3	Cherry Rivets
------	--------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet M104715

*EPB 7/16/07*

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Job Number: 33548

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS21042L3

Nut



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M104547

26.0

MS21042L4

Nut



*CP*



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

9 MS21042L4 Nut (or -4) M102552

27.0

MS21042L5

Nut



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M104118

*CP 7/08/02*

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal Support Gusset with Sikaflex -291

Batch: M104732

Exp Date: 10/2007

*ml 07/08/02* X1

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En 07/08/02* (X1)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

Date: Monday, 7/16/2007 2:43:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 33548

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	D22301	Mounting Lug
------	--------	--------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

B32163-

32.0	D22303	Mounting Lug
------	--------	--------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

B30923-

33.0	D23241	Strut Assembly
------	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 \*D2324-1

Strut Ass'y

B32278-

34.0	D2856400	Abrasion Strip
------	----------	----------------



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2856-400-720 Abrasion Strip

B32992-

35.0	AN412A	Bolt
------	--------	------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M104547-

36.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M104746-

Date: Monday, 7/16/2007 2:43:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 33548

Part Number: D350607043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

37.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

26 AN960JD416 Washer M104215-

38.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

13 MS21042L4 Nut (or -4) M102552-

39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

40.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-043

Location: E

41.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------

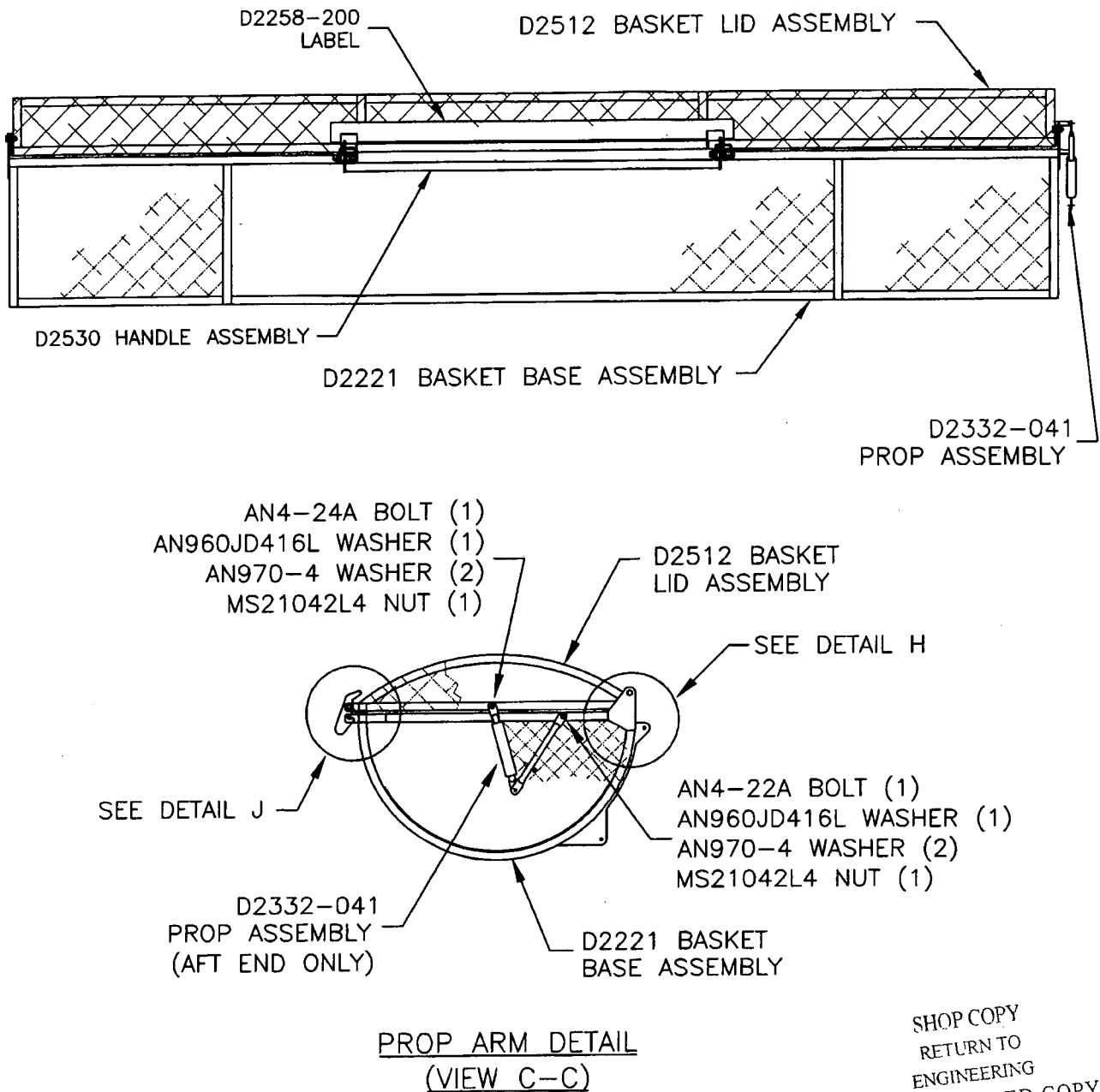


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



7/17/07.08.03.



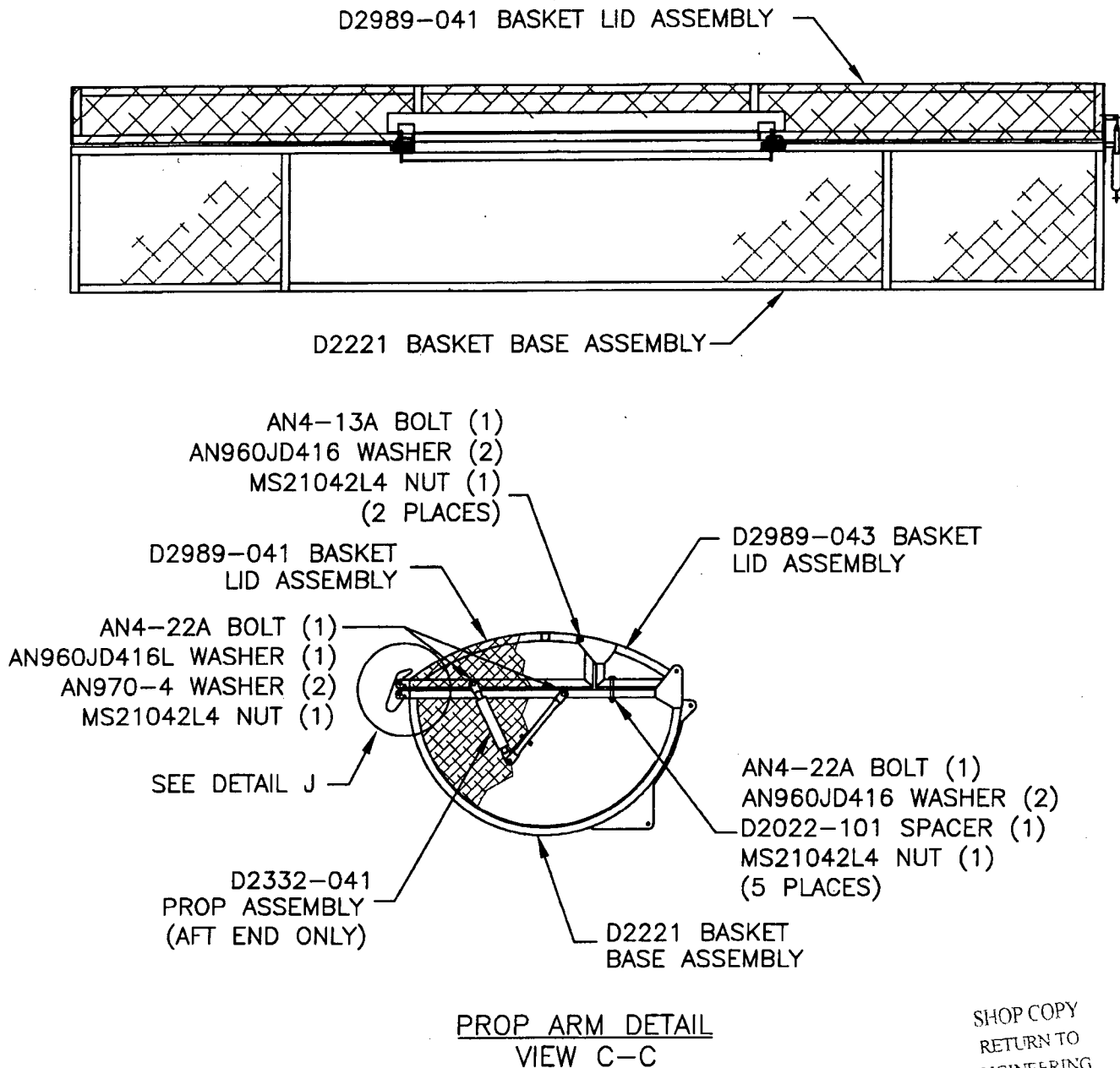
**Figure 4 – Basket Replacement Parts**  
(D350-607-041 Heli-Utility-Basket™)

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 33548

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Revision: **F**  
Date: 03.01.17



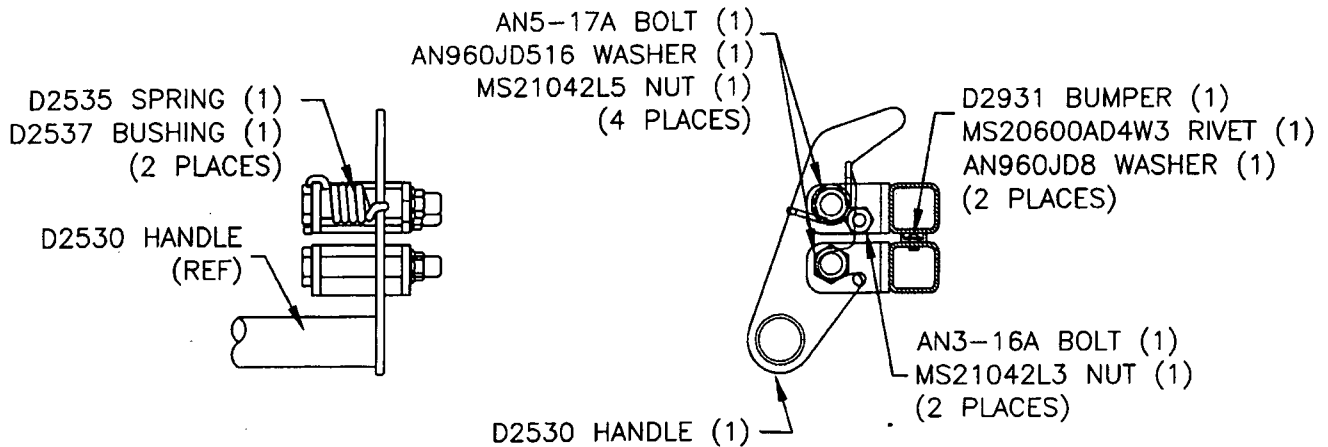


**Figure 5- Basket Replacement Parts**  
(D350-607-043 Heli-Utility-Basket™)

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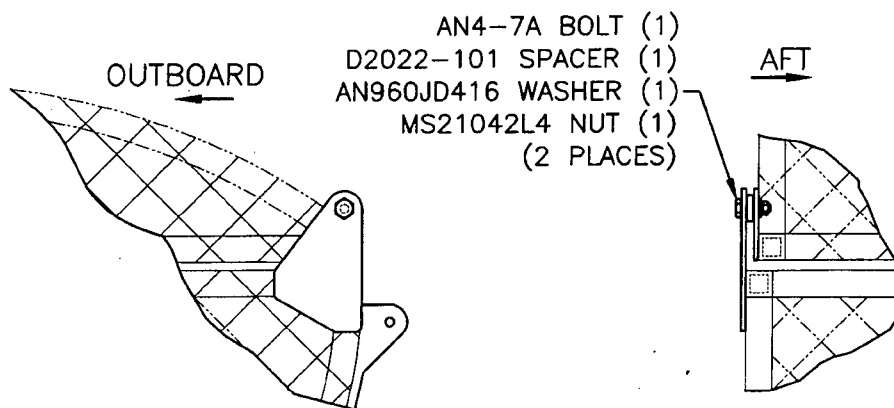
Revision: F  
Date: 03.01.17



SPRING DETAIL

LATCH DETAIL

DETAIL J:  
HANDLE WELDMENT



HINGE DETAIL  
END VIEW, LOOKING AFT  
OTHER END OPPOSITE

HINGE DETAIL  
SIDE VIEW, LOOKING OUTBOARD.  
OTHER END OPPOSITE

DETAIL H:  
HINGE

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NO. 33548

Figure 6 - Basket Replacement Parts

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Revision: F  
Date: 03.01.17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

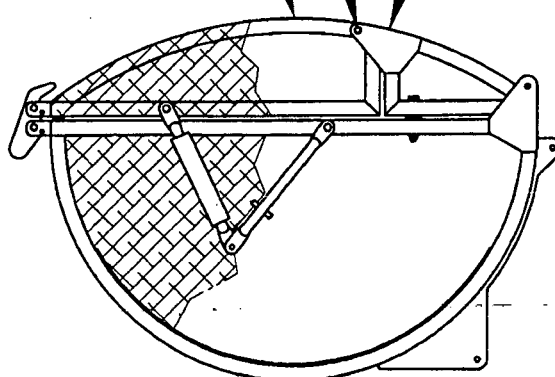
To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:

AN4-13A BOLT (1)  
AN960JD416 WASHER (1)  
HINGE PLATE (REF)  
**NAS1515H4 WASHER (1)**  
BASKET FRAME (REF)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES)

BASKET FRAME (REF)

HINGE PLATE (REF)



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NO. **33548**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE #02)

DATE: 06.01.06  
CERT. NO.: SH94-14  
ISSUE NO.: 4

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Date: Monday, 7/16/2007 2:43:39 PM  
 User: Kim Johnston

## Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 33548A	
Estimate Number : 10206	
P.O. Number : <i>N/A</i>	Part Number : D2989041
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2989 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 33389A	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.07.17	
Comment : Est Rev: Removed D2989-043 05-11-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: *3336882*

*Ppl 07 07 31*

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch  
 2 D2581 Mounting Brackets *332066*

*Ppl 07 07 31*

3.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch  
 2 D2327-3 Bushing *330876*

*Ppl 07 07 31*

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch  
 1 D2506 Label Plate *337786*

*Ppl 07 07 31*

Date: Monday, 7/16/2007 2:43:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 33548A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number Description Batch

15sf M304EX0.75-16F Expanded Metal

*m104711*

*Pl 07 07 31*

6.0

M304TS0750W065

304 SQ Tube. 75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: *m104980*

*Pl 07 07 31*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

*Pl 07 07 31*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-07-31 ①*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PD 07-07-31 ①*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*m104068*

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

*PRESSURE WASH BR 07-07-31.*

*FA 07/07/310*

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 33548A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black:

Wing Walk:

M104941  
M104942

m.d

07/08/01

①

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

ml 07/08/02

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/03

Job Completion



07-08-02.



DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05.08.19 H

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

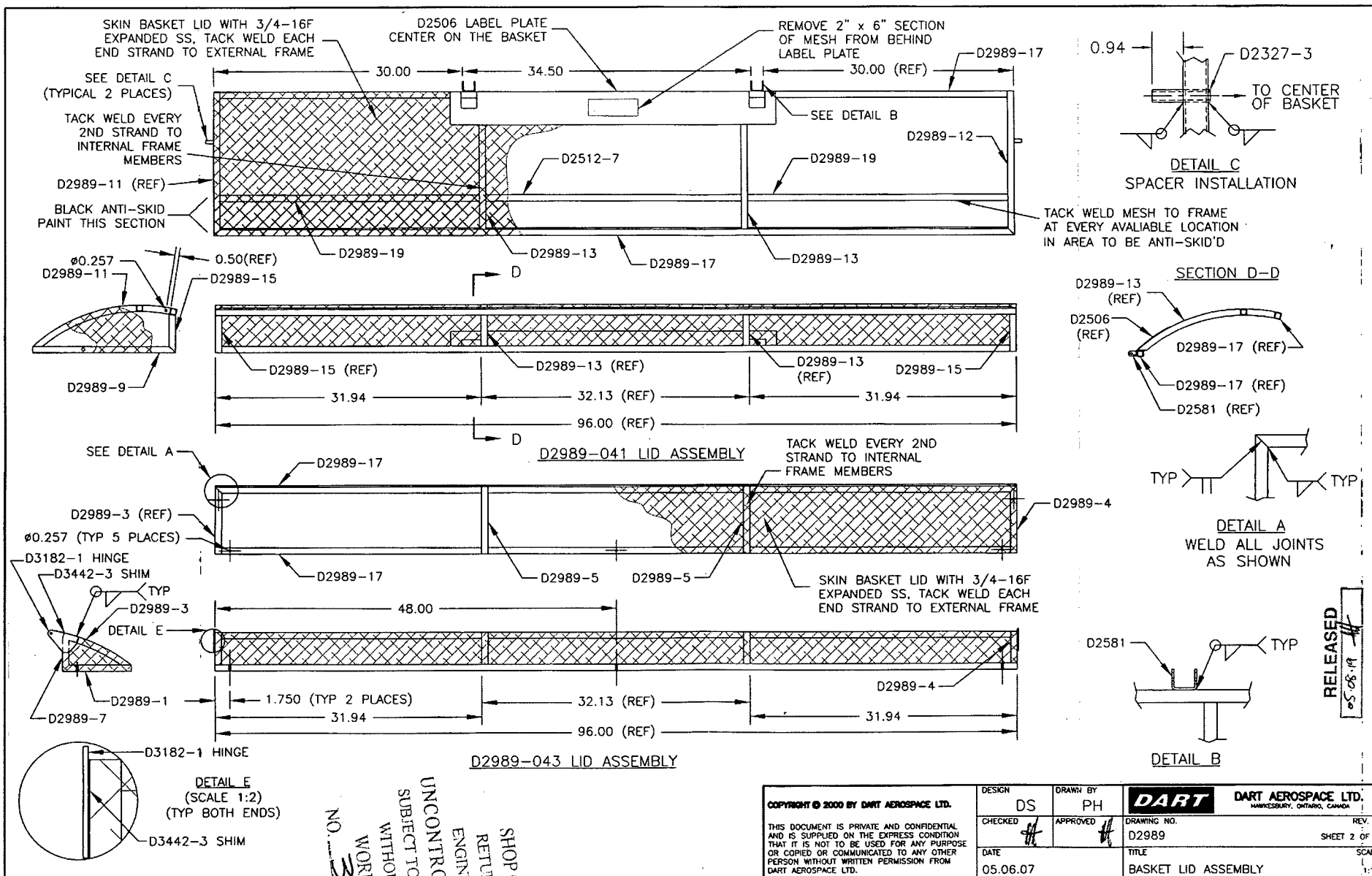
**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING  
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI-005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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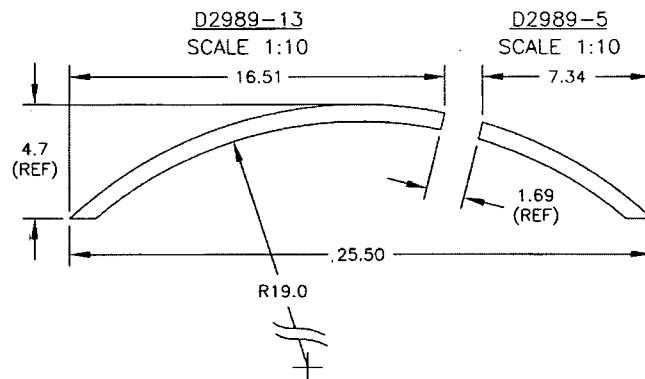
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NO 33548A



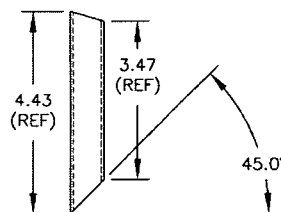
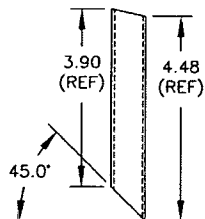
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CHECKED	#	APPROVED	#	DRAWING NO.		REV. B	
DATE		05.06.07		D2989		SHEET 2 OF 3	
TITLE		BASKET LID ASSEMBLY		SCALE		1:10	



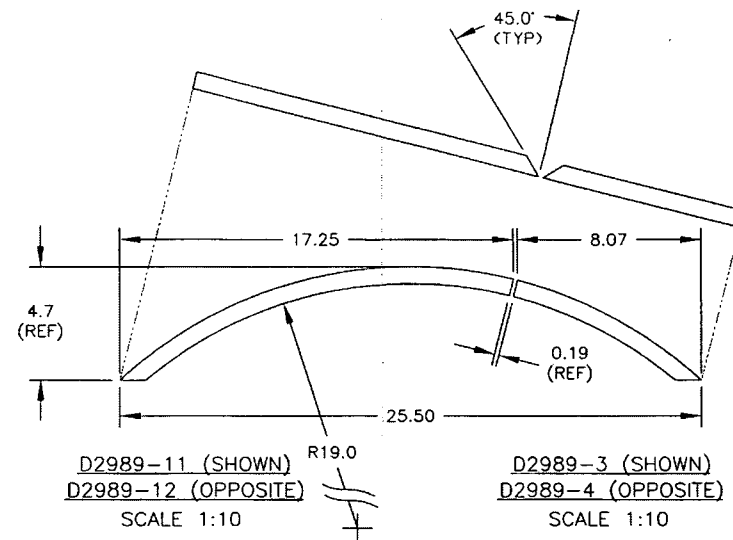
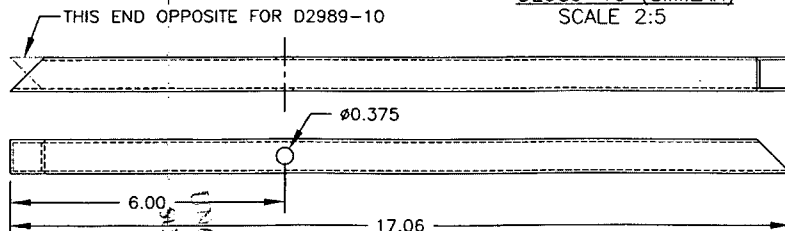


D2989-15  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

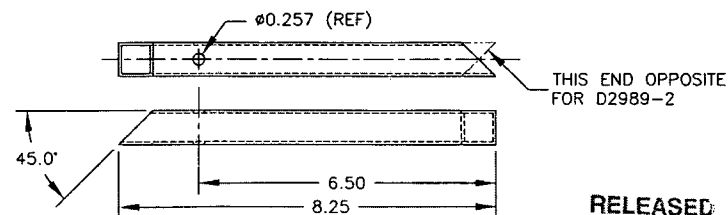
D2989-7  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)  
D2989-10 (SIMILAR)  
SCALE 2:5



D2989-1 (SHOWN)  
D2989-2 (OPPOSITE)  
SCALE 2:5



RELEASED

05-08-19

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DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. BARRIE, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

NO. 335787  
WORK ORDER  
SUBJECT TO AMENDMENT  
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ENGINEERING  
RETURN TO  
SHOP COPY

Date: Monday, 7/16/2007 2:43:45 PM  
 User: Kim Johnston

## Process Sheet

31

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 33548B		
Estimate Number	: 10207		
P.O. Number	: <i>N/A</i>	Part Number	: D2989043
This Issue	: 7/16/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2989 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 33389B	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/30/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev: Removed D2989-041 05-11-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	D3182-1	Hinge	<i>B33286</i>

*Pd 07 07 31*

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	D3442-3	Shim	<i>B26740</i>

*Pd 07 07 31*

3.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty	Part number	Description	Batch
8sf	M304EX0.75-16F	Expanded Metal	<i>M104711</i>

*Pd 07 07 31*

4.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SS tubing.

Batch: *M104980*

*Pd 07 07 31*

Date: Monday, 7/16/2007 2:43:45 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 33548B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

*CP 07 07 31*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-07-31 ①*

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*PD 07-07-31 ①*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*m/05068*

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

*PRESSURE WASH BR 07-07-31*

*FL 07/07/31 ①*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

*m/07/08/02*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*① 2007/08/03*

Job Completion



*07.08.02*



DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

**RELEASED**

05.08.19 H

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

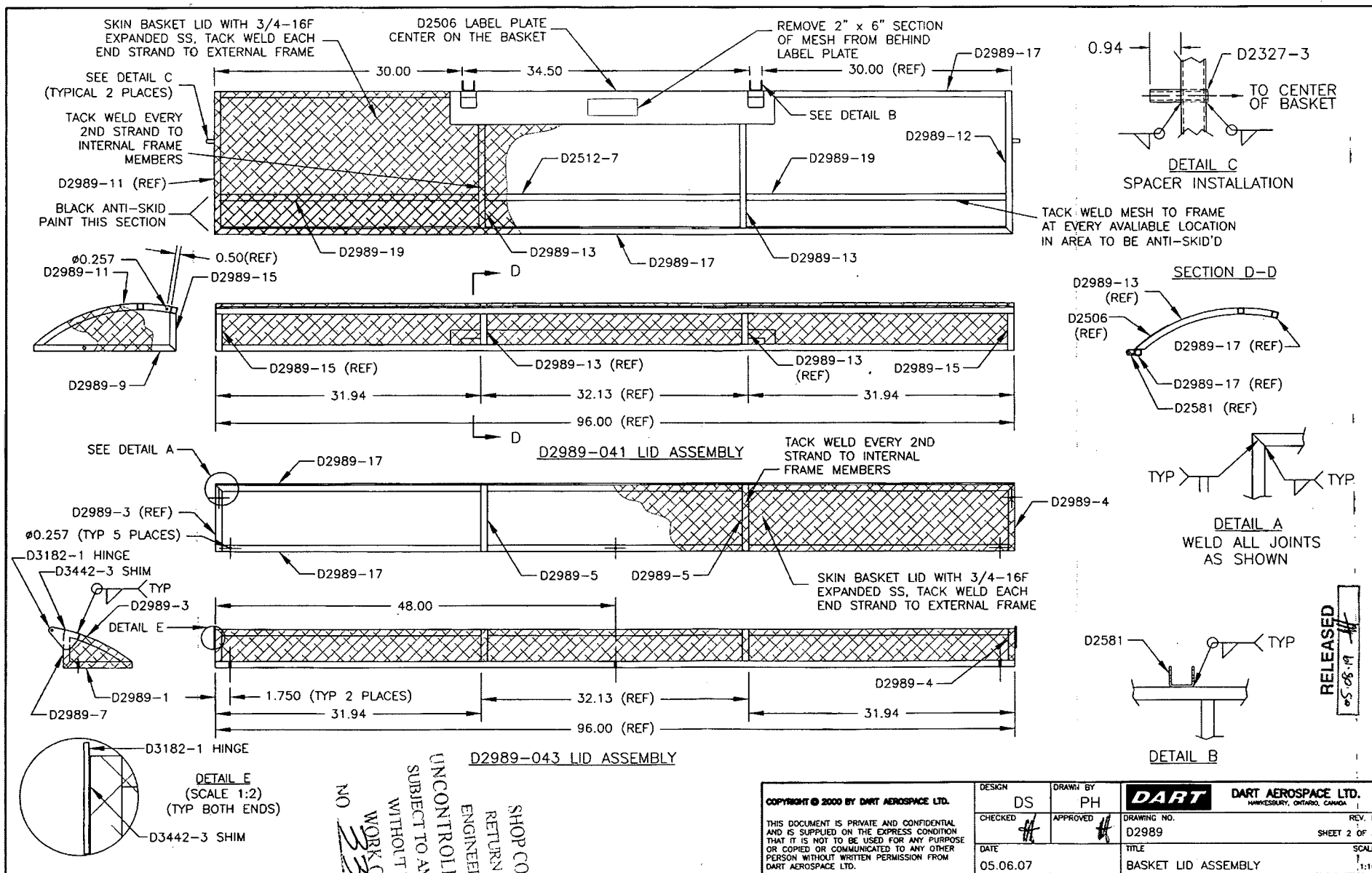
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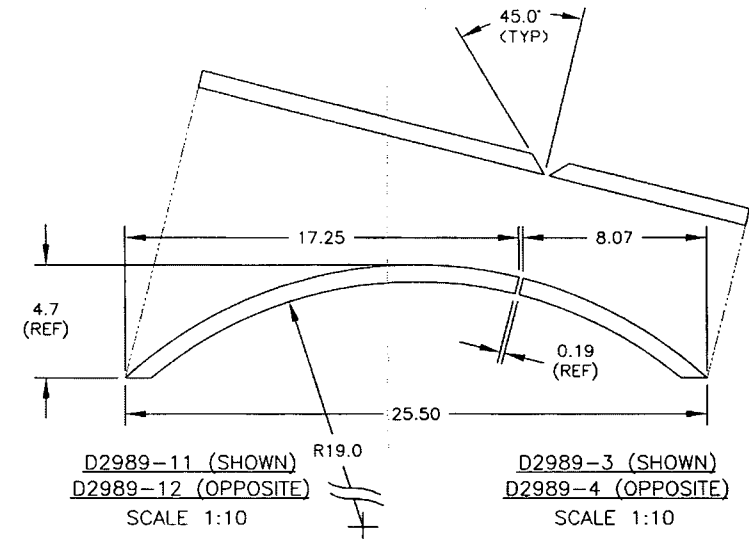
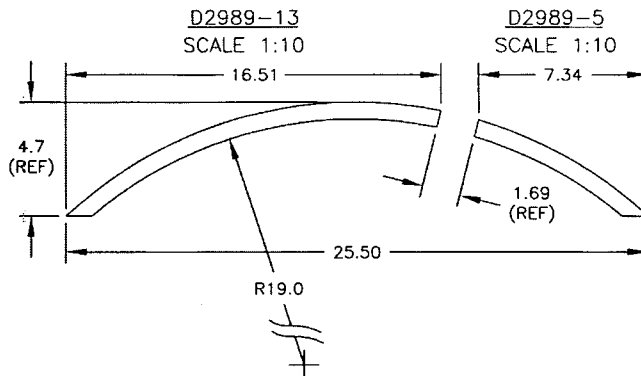
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING  
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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33548 B

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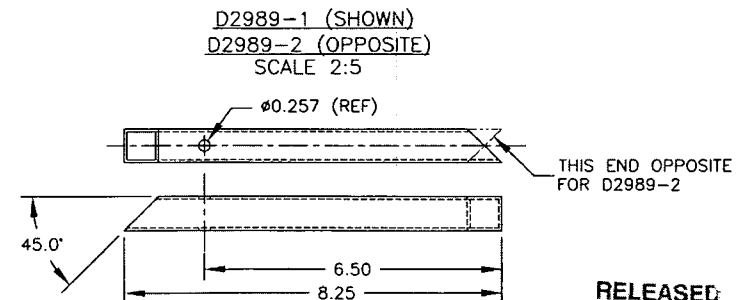
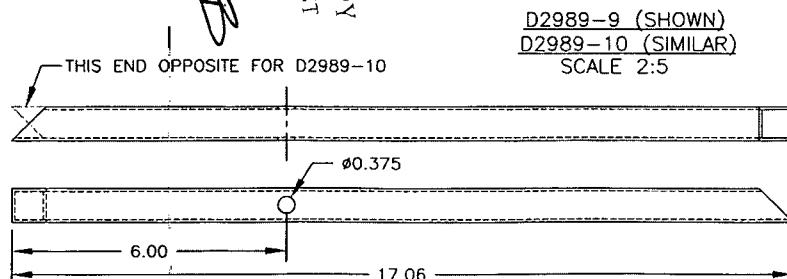
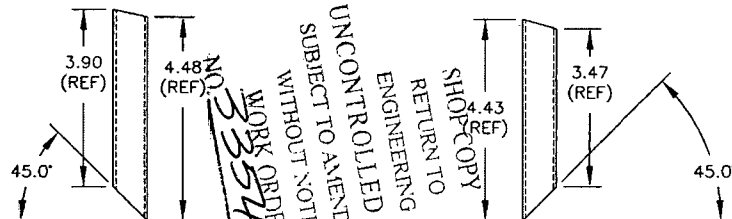
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D2989-15  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



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CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

# Process Sheet

Form: rprocess

Date: Monday, 7/16/2007 2:43:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 33548C

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

*332066*

*Pl 07-07-31*

6.0	D34421	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim

*332875*

*Pl 07 07 31*

7.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal

*M104711*

*Pl 07 07 31*

8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: *M104980*

*Pl 07-07-31*

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

*Pl 07-07-31*



Date: Monday, 7/16/2007 2:43:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 33548C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-31

①

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 07-07-31

①

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/m/07-07-31

②

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m/07/08/02

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

209/08/03

Job Completion



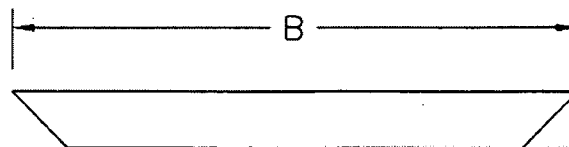
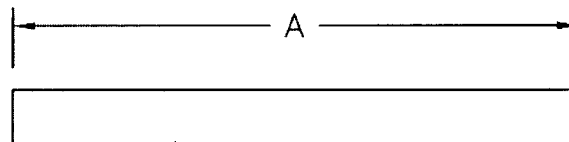
7/07-08-02

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

**RELEASED**05.08.19 *[Signature]*PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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D2221-1/-3/-5/-7

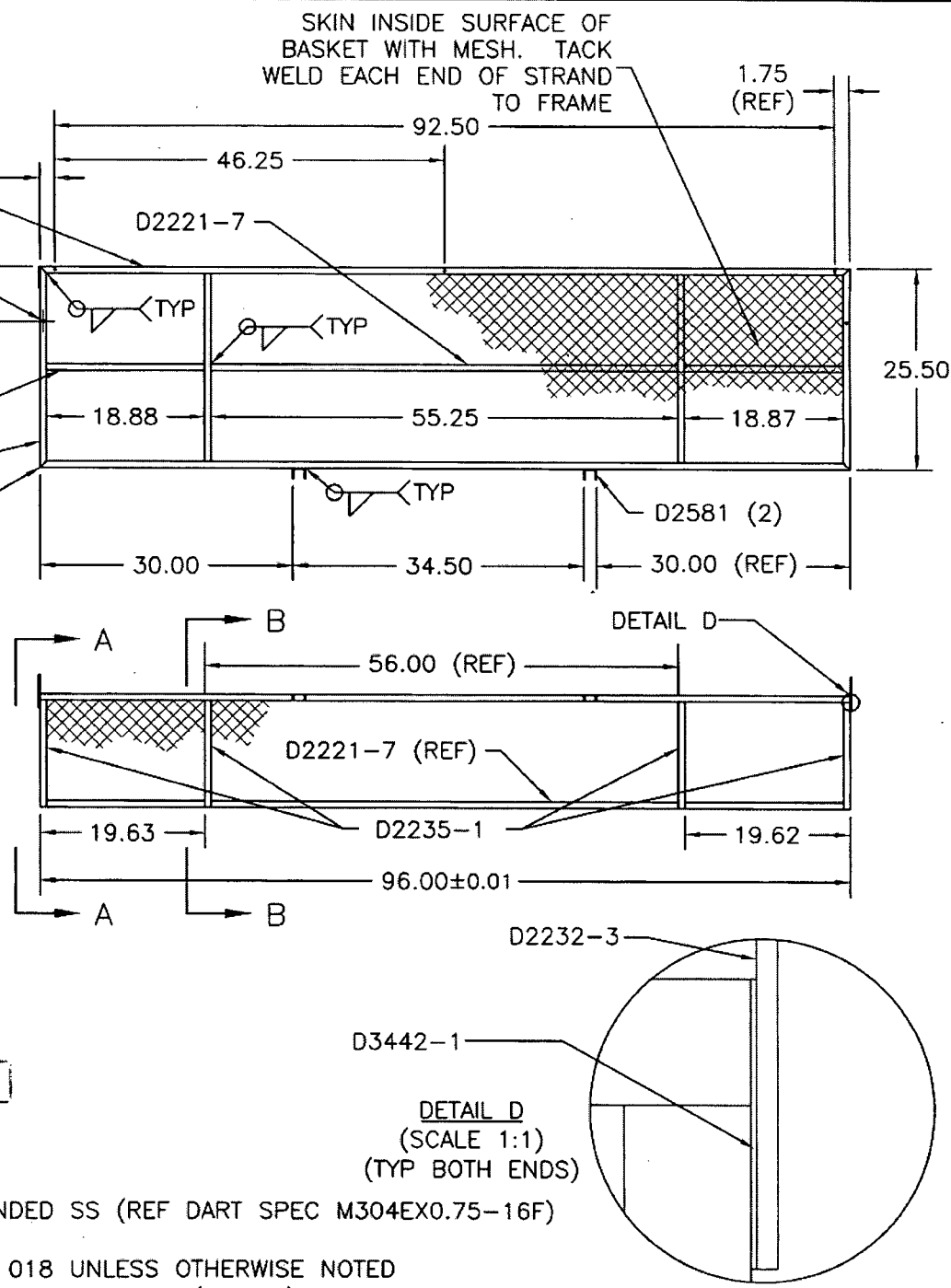
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL  $\phi 0.257$  HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH  
D2989-041/-043 BASKET LID

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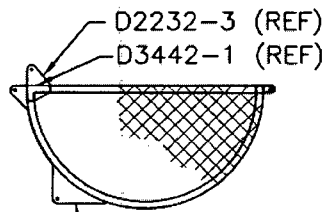
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BW	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.06.07		D2221
DATE	TITLE	SHEET 2 OF 3
	BASKET BASE ASSEMBLY (350)	SCALE
		1:20



5  
Ø0.257 (TYP 5 PLACES)  
(DRILL WHEN ASSEMBLING WITH  
D2989-041/-043 LID ONLY)



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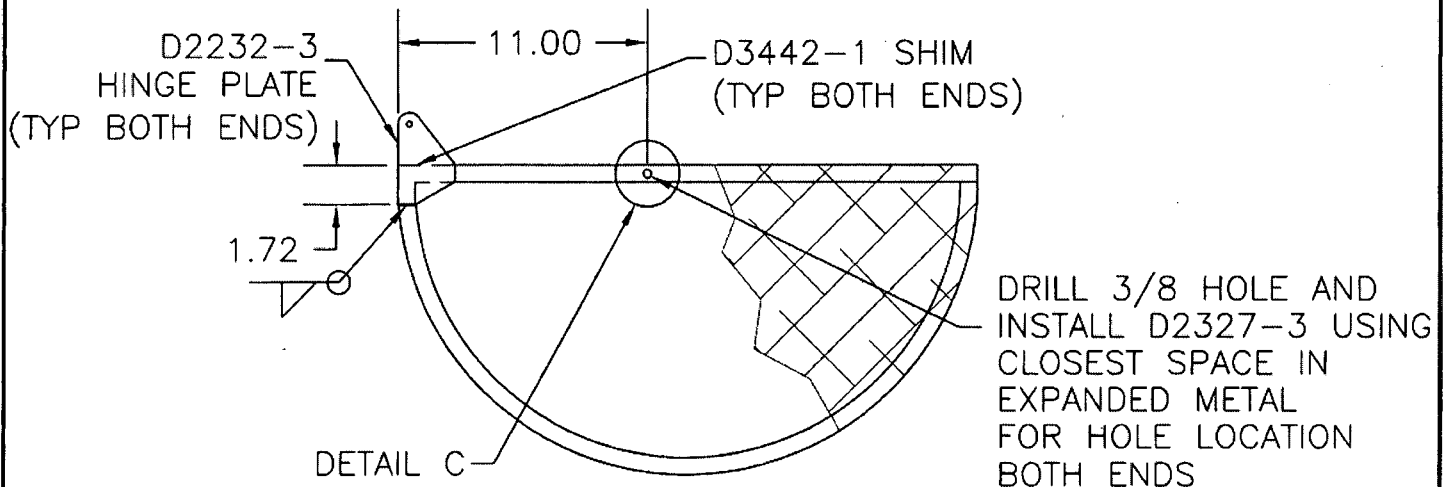
05.08.19

D2221 BASKET BASE ASSEMBLY

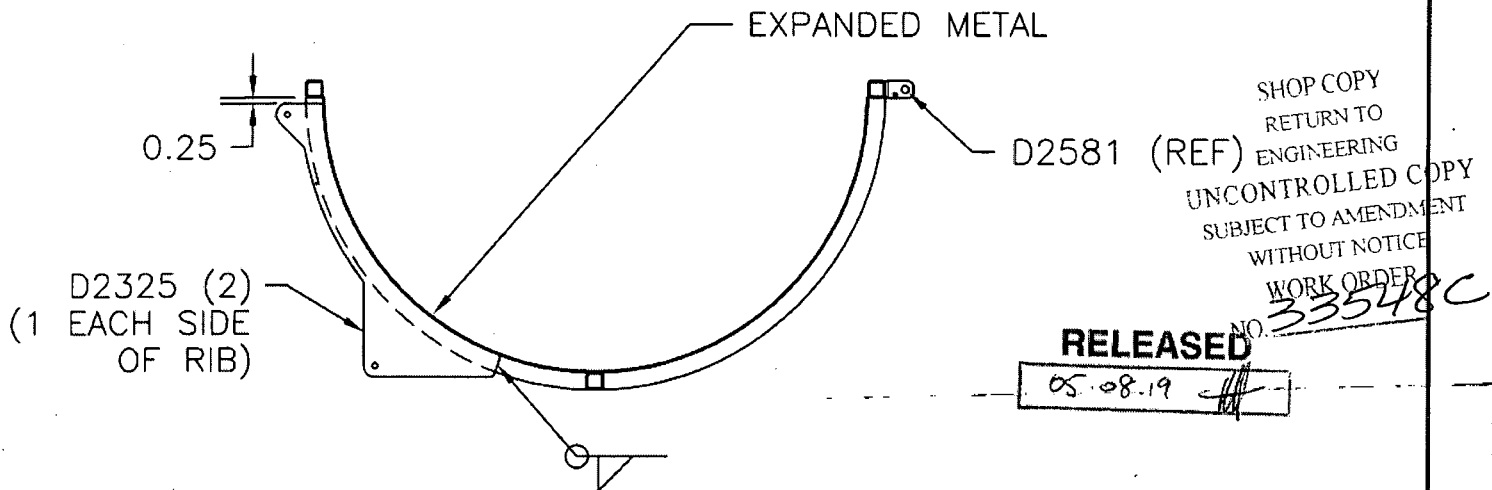
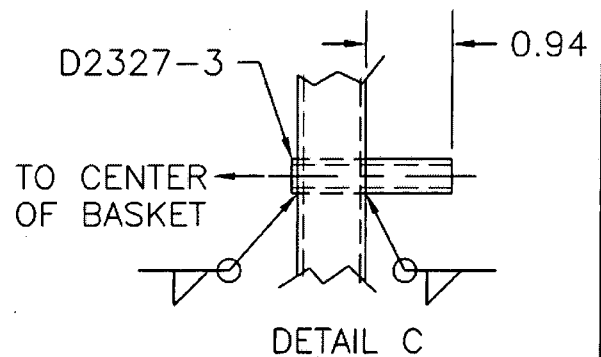
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE 1:8



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

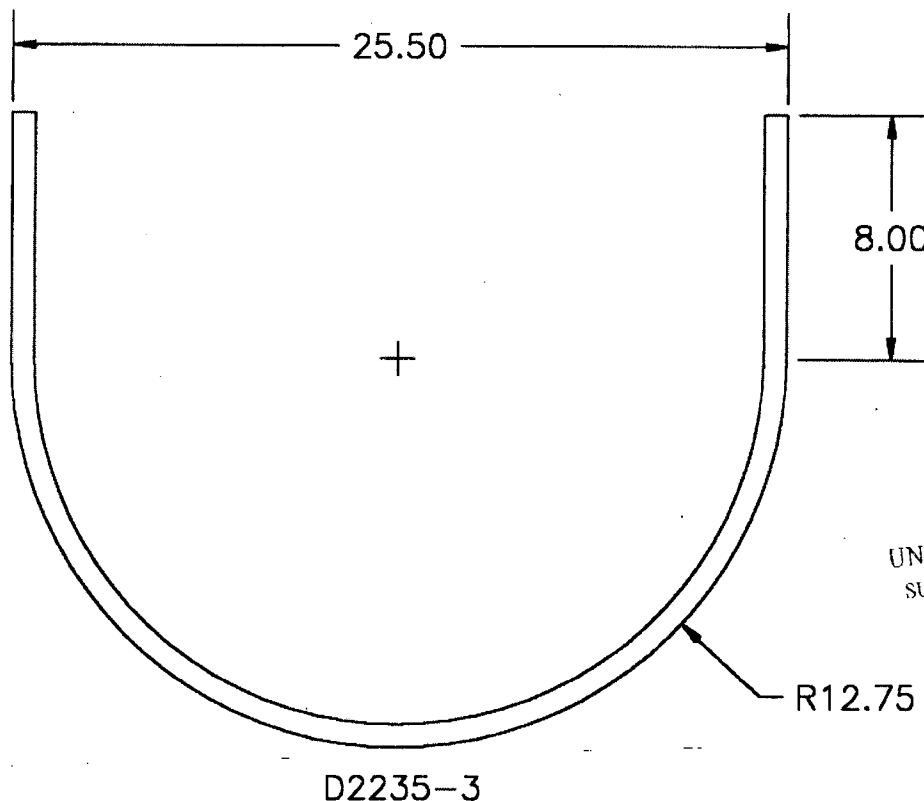
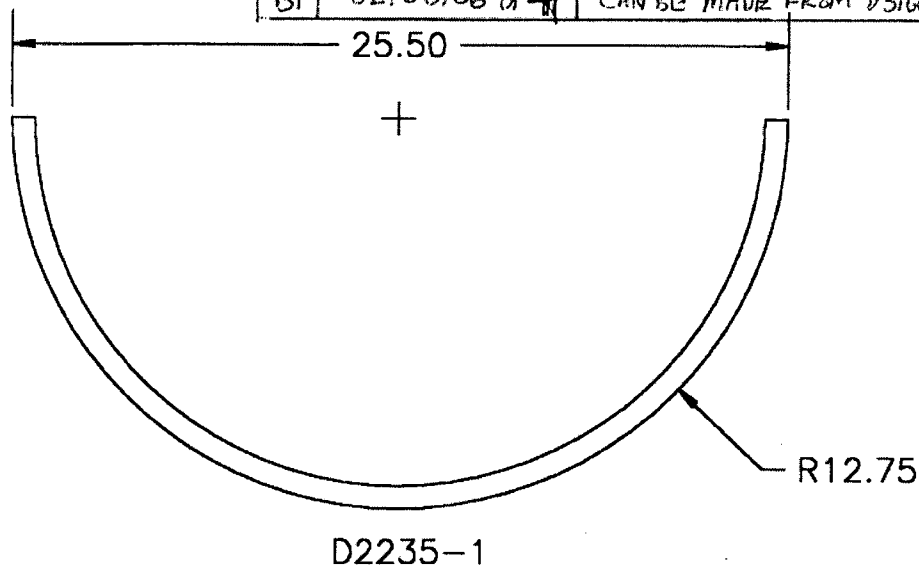
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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>SW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE
BI	02.08.06 <i>11-1</i>	CAN BE MADE FROM D3166-1	

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R 960507



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CAN BE MADE FROM D3166-1 *BI*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.